Work Order	ID	661	95
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February 7, 2011 12:38:57 PM

Quality Control



Page 1

Accept Item ID: D3248-1 Setup Start **Revision ID:** Stop Doubler Item Name: Start Qty: 8.00 **Start Date:** 2/07/11 **Cust Item ID:** Required Date: 2/18/11 Req'd Qty: 8.00 **Customer:** Reference: Start Run Date: 110207 Tooling: Process Plan: Approvals: Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Reject Operation Set Up/ Accept Reject Tool ID Tool # Plan Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D3248 Rev A 100 0.00 **PURCHASING** B11-2-7 0.00 Waterjet Memo FLOW CNC Waterjet 1-Cut as per Dwg 5052.063 Dwg Rev: Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 PB11-2-7 QC 0.00 Memo

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		<u></u>	*******						- "-
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	on:	_ QA: N/C CI	osed:	-	Date: _	
NCR:		1	WORK ORD	ER NON-CONFORMA	ANCE (NCF	R)			
DATE	STEP	Description of NC			ion B		cation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		tion C	Chief Eng	QC Inspector
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	-							}	

Work Order ID 66195

February 7, 2011 12:38:57 PM



Page 2

Item ID:

D3248-1

Accept

Setup Start

Revision ID:

Item Name:

Required Date: 2/18/11

Doubler

Start Date:

2/07/11

Start Qty: 8.00

Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date:

Run

Start

Stop

Stop



Work Center ID

Sequence ID/

QC:

Date:_____

SPC (Y/N):

Date:

Reject

Reject Insp.

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Qty

Number

Stamp

130

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

140

QC

QC3- Inspect Part Finish

Memo

0.00

0.00

Quality Control

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector
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	R	esolution:	Dispositio	n:	QA:	N/C Clo	sed:		Date: _	
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DATE	CTED	Description of NC			ction B		Verific	cation	Approval	Approval
DAIE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
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Work Order ID 66195

Page 3

February 7, 2011 12:38:57 PM

Item ID:

D3248-1

Revision ID:

Item Name:

Doubler

Start Date:

Start Qty: 8.00 2/07/11

Required Date: 2/18/11 Req'd Qty: 8.00

Accept

Date:

Date:

Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date:__ Tooling:

SPC (Y/N):

Run

Start



Stop

Sequence ID/ **Work Center ID**

150

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty

Number

Stamp

160

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

Dart Aerospace

W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				B16-04-0-4						
Part No	·	PAR #:	Fault Categ	ory:	NCF	: Yes N	o DQA	۸:	Date: _	·
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DATE	STEP	Description of NC			ection B	Cian 9	Verific		Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector

Picklist Print

February 7, 2011 12:38:57 PM

Work Order ID: 66195

D3248-1 Parent Item:

Parent Item Name: Doubler



Start Date: 2/07/11

Required Date: 2/18/11

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP B 04.10.26 D3248-1 no longer made in-house.

11.02.07 now made on W.J. DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063	•	Purchased	No			100	sf	148.6000	0.0937	0.789053	1.3		
										f	-G-1) \$	7	

5052-H32 .063 Sheet

Loc Code Location Loc Qty 148.6 MAT 114322 148.6

Page 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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				1.18.0000 - 10.0000								
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Part No		PAR #:	Fault Categ	jory:	_ NCR: Yes	No DG	A:	Date:				
	R	esolution:	Disposition	:	_ QA: N/C CI	osed:	***	Date:				
NCR:			WORK ORDE	ER NON-CONFORM	ANCE (NCF	(1)						
DATE	STEP	Description of NC			ion B Sign 8		cation		Approval			
DAIL	O I L	Section A	Initial Chief Eng	Action Description Chief Eng	Date	Sec	tion C	Chief Eng	QC Inspector			
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DART AEROSPACE LTD	Work Order:	late 075 66 195
Description: Doubler	Part Number:	D3248-1
Inspection Dwg: D3248 Rev: A		Page 1 of 1

	FIRS	T ARTICLE II	NSPECTION	ON CHE	CKLIST		
		X First Arti	cle	Proto	otype		****
Drawing	Tolerance	Actual	Accept	Reject	Method of	Co	mments
Dimension	Tolcranoc	Dimension	жооорс		Inspection		
R0.50	+/-0.030	, 4 0	ω		R.G		,
3.60	+/-0.030	3,608	>		V		
Ø0.257	+0.005/-0.00	00 ,760	8		V		
Ø0.128	+0.005/-0.00	CE), 00	>		V		
0.38	+/-0.030	,381	≻		V		
1.000	+/-0.010	1.000	8		V		
3.75	+/-0.030	3,752	>		V		
0.38	+/-0.030	.378	>		V		
R0.38	+/-0.030	138	2		R.G.		
2.000	+/-0.010	3.0X)	y		V		
2.625	+/-0.010	2,625	১		V		
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			A				
Measured by:	退	Audited by:	11/11		Prototype Ap	proval:	N/A
Date:	11 ~ ~	Date:	11.02.	00		Date:	N/A

Measured by:	Audited by:	18/18/	Prototype Approval:	N/A
Date: 11-3-7	Date:	11.02.08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	
			• (1	

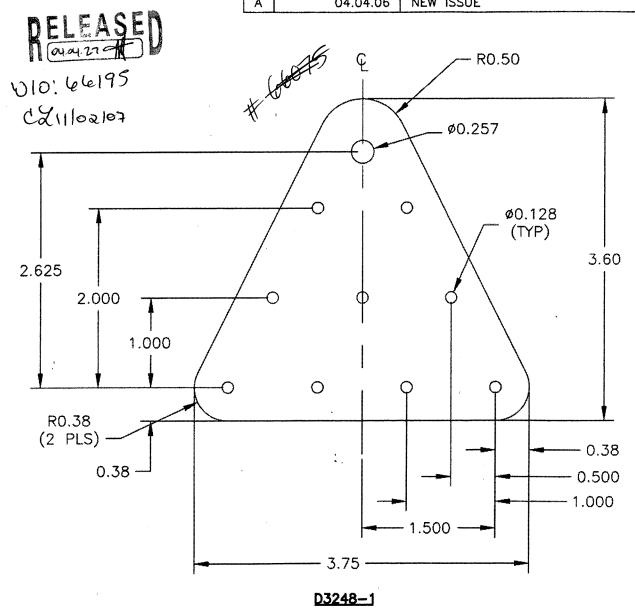
Dart Aerospace Ltd	Da	rt A	ero	spa	ce	Ltd
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W/O:			WO	RK ORDER CHANG	ES					
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NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)				
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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DESIG	N H	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA							
CHEC	KED	APPROVED -	DRAWING NO. D3248	SHEET	REV					
DATE			TITLE		SC	AL	E			
04.0	04.06		DOUBLER			1:	:1			
٨		04.04.06	NEW ISSUE							



NOTE:

- 1) MATERIAL: 5052-H32/H34 SHEET (QQ-A-250/8) 0.063 THICK (REF. DART SPEC. M5052H32S.063)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) PART IS SYMMETRIC ABOUT CENTERLINE

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DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date: _		
	R	esolution:	_ Disposit	ion:						
NCR:		W	ORK OR	DER NON-CONFORM	MANCE (NCF	R)				
DATE	OTED	Description of NC	. Corrective Action Section B			Veritication		n Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 6		tion C	Chief Eng	QC Inspector	
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